

ABSTRACT

In a manufacturing method for injection-molded and in-mold decorated articles including injection of molding resin (4) into a molding space (3) defined by a decorating film (5) and a mold (1), the molding space has a product molding space (31) and a resin-discharging-use molding space (33) which is formed around the product molding space and into which the molding resin is let to flow for discharge of the molding resin from the product molding space. The molding resin is injected into the product molding space, and while part of the injected molding resin is discharged from the product molding space into the resin-discharging-use molding space, the molding resin is filled into the product molding space.